Work Orde September-23-1						Page 1					
Item ID: Revision ID: Item Name:	D3023-1 Back Panel			Accept	*N900	<u>04</u> 0	100) *	Setup Sta	1 7	S1* S2*
Start Date: Required Date: Reference:	10/01/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				N	. 17
Approvals:	Process Pla	an: ML5	Date: 13-09-2	Y Tooling: SPC (Y/N):		ate:		1	Run Sta Ste		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3023	Rev	/ A									
*100 *100* Waterjet FLOW CNC Waterje	et .	FLOW WATER JET Memo	- Dwg D3023	0.00				1	d		Az 13.10.01
Z024 ·03		Dwg Rev: Prog Rev: ***graind d	A irection along 28.100" **	**							
110		2-Deburr if QC2- Inspect parts off m		0.00				í	.\		
110 QC		Memo		0.00					<u></u> ひ_		13:10:01

Quality Control

									•		DQA:	Date	•
NCR:	res /	No				WORK ORDER NON-C	O	NFORN	MANCE / UPDATI				
											QA Closed:	Date	•
Work Orde	or.					DISPOSITION			A	GAINST DE	PARTMENT	PROCESS	
WOIN OIG	-''-					Rework	1		Skid-tube Cro	osstube		Water Jet	Engineering
Part N	No.					Scrap	1			mall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Therm	oforming F	inishing	Rec/Sto	e/Packaging	Other
NCR N	No					Work Order Update]		Large Fab Cor	mposite		Supplier	
Root					Descri	ption of work order update		nitial	Action		Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							Ì						
Operator													
Material							1						
Setup													
Other													
Process							}						
Supplier		1					1		•				
Training													
Unapproved													
						F	AUL	T CATE	GORY			<u></u>	·
Landi	ng Gear					General	_	_					-
	Ber	ding				Bend		Grain			Ovalized		Pressure/Forced
	Cer	itre No	t Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	cks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Cru	shed/0	Crimped			Burrs		Instruct	ions Incomplete/Unclea	ar	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf	fs				Contamination		Mainte	nance		Part Moved		
	He	at Trea	t ·			Countersink		Mislabe	led		Positioned V	Vrong	-
	Ins	pection	Strip in	Tube		Cut Too Short		Misread	İ		Power Loss/	Surge	Other
	Rip	ples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Order ID 107147 *107147* Page 2 September-23-13 11:09:52 AM Item ID: D3023-1 Accept *N900040100* Setup Start Revision ID: Stop Back Panel Item Name: Start Qty: 1.00 10/01/13 **Start Date: Cust Item ID: Reg'd Qty:** 1.00 Required Date: 10/01/13 **Customer:** Reference: Run Process Plan: Tooling: Date: Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Reject Reject **Operation** Set Up/ Tool ID Tool # Plan Accept Insp. Work Center ID Description Qty Qty **Run Hours** Code Number Stamp 120 QC8- Inspect parts - second check 0.00 OAS *120* D 13-10-01 QC 0.00 Memo Quality Control 130 Form as per dwg 0.00 *120* Brake NC 0.00 Memo Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

*1*4*∩*

Memo

0.00

Quality Control

1310.0g

60

											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-C	100	NFORM	/ANCE / UP	DATE	QA Closed:	Date:	
						DISDOSITION				A CAUNCT DE			
Work Orde	er:					DISPOSITION				AGAINST DE	PAKTIVIENT,	/PRUCE33	<u>.</u>
Part f	 No					Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No					Work Order Update]		Large Fab	Composite]	Supplier	
Root					Descri	ption of work order update	ı	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						•							
Equip/Tooling	Ц												
Operator													
Material	Ш												
Setup	Ш												
Other	Ш												
Process	Ш		Ì										
Supplier	Ш												
Training	Ш												
Unapproved		·					<u> </u>						
							AUL	T CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi	ng Ge	ar				General	_	1		_	7	-	7
	∐В [,]	ending			<u> </u>	Bend	L	Grain		<u> </u>	Ovalized		Pressure/Forced
		entre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa			Over/Under	 	Temperature/Cure
	-	racks				Broken/Damaged		4	ion Incomplete		Part Incorre		Weld
		rushed/	Crimped			Burrs		4	ions Incomplete/	/Unclear	Part Lost/M		Wrong Stock Pulled
	Цс	uffs				Contamination		Mainte	nance		Part Moved		
	Щн	eat Trea	it			Countersink		Mislabe	led		Positioned \	Wrong	7
	l lie	snection	n Strin in	Tuhe		Cut Too Short		Misread	4		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work O	rder ID	1071	147
September-2.			
Item ID:	D3023-		

107147

Page 3

September-23-	13 11:09:52	4M	4 to 100		· — /					
Item ID: Revision ID:	D3023-1			Accept	*N9000	<u>140</u>	100	* S	Setup Star	*NS1*
Item Name:	Back Panel								Sto	° *NS2*
Start Date:	10/01/13	Start Qty: 1.00	*1*		Cust Item ID) :				
Required Date	e: 10/01/13	Req'd Qty: 1.00	*1*		Customer:					
Reference:								•	S4	
Approvals:	Process Pl	an:	Date:	Tooling:	Dat	te:		ŀ	Run Star	"NR1"
	QC:		Date:	SPC (Y/N):	Dat	te:			Stop	° *NR2*
Sequence ID/ Work Center	ID	Operation Description	. 1	Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Insp. Number Stamp
180		Identify as per dwg & St	ock Location:	0.00				\sim		
180 Packaging		Memo		0.00				0	E	13-10-2
Packaging										
									1	
190		QC21- Final Inspection	- Work Order Release	0.00				V	1/0	1,0,1
190 QC Quality Control		Memo	·	0.00			_) M	13-10-1
									1	

								*			DQA:	D	ate:		
NCR: Y	es / N	o		٠.	WORK ORDER NON-C	COI	NFORM	/ANCE / UPI	DATE		0.4.01				
					T				·		QA Closed:	ָט	ate:		
Work Orde	s r .			-	DISPOSITION				AGAINST D	NST DEPARTMENT/PROCESS					
Part N	lo				Rework Scrap Use-as-is		Machining Small Fab		Crosstube Small Fab Finishing	Prod. Eng. Co Rec/Store/Packag				Engineering Quality Other	
NCR N	10				Work Order Update	_		Large Fab	Composite	╛		Supplie	r		
Root			Т	Descri	ption of work order update	Π	Initial	Act	tion	٦	Sign &				
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	ription		Date	Verificati	on	QC Inspector	
Doc/Data															
Equip/Tooling						Ì									
Operator															
Material											1				
Setup		İ													
Other															
Process															
Supplier						1									
Training	Ц														
Unapproved				<u> </u>						┙					
						AUL	T CATE	SORY							
Landii	ng Gear			_	General		1		Г	_	ا براجا			la <i>(</i> a ,	
	Bend				Bend	\vdash	Grain		_	-	Ovalized		\vdash	Pressure/Forced	
i	\vdash	e Not Conc	entric to	^{O/S} -	BOM/Route	\vdash	Hardwa		-	-	Over/Under		\vdash	Temperature/Cure Weld	
	Crack		•	<u> </u>	Broken/Damaged	\vdash	-1	on Incomplete			Part Incorred		_	ł	
		ed/Crimpe	a	<u> </u>	Burrs	-	4	ions Incomplete/l	Unclear	_	Part Lost/Mi	ssing	<u> </u>	Wrong Stock Pulled	
	Cuffs	T		<u> </u>	Countarink	\vdash	Mainte		-		Part Moved Positioned V	Vrong			
	Heat		ta Tula e	<u> </u>	Countersink	-	Mislabe		-	_	Positioned v	-		Other	
	—	ction Strip i	ın Tube		Cut Too Short		Misread	i	L		rower Loss/	ourge	L	Other	
	$oldsymbol{eta}$	es in Bend	. F	_	Drill Holes	-	Offset	~ulibuation							
	lorqu	ie Waves in	ı Extrusio	n [Drawing	1	JOUT OF C	Calibration						<u>.</u>	

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

Picklist Print

September-23-13 11:09:52 AM

Page 1

Work Order ID:

107147

Parent Item:

D3023-1

Parent Item Name:

Back Panel

Start Date: 10/01/13

Required Date: 10/01/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP C02.01.23Revised

IDD Decado Al Company system int DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	537.9412	2.8777	*3.029 1579	The	13 .	10.0
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT022		537.9412							
				11824	13	32.3562				<u> </u>			
				11852	23	141	•						
				12130)9	68.656							
				12309	96	27.6							
				12357	74	81.9					. •9	m 7	
•				12498	37_	186.429			12	4981 -	7 5	,03	

												DQA:	Dat	e:	
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFOR!	MANCE / UP	DATE		·			
											_	QA Closed:	Dat	e:	·
Work Orde	sr.					DISPOSITION				AGAINST ()E	PARTMENT	/PROCESS		
Part N	Part No. NCR No. Descri				Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other			
Root		ï				ption of work order update		nitial		tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	_	Date	Verification	니	QC Inspector
Doc/Data															
Equip/Tooling											,				. *
Operator	_		Į.			•									
Material							İ								
Setup															
Other					1									ı	
Process					, ,									ľ	
Supplier															
Training															
Unapproved							<u> </u>								
						F	AUL	T CATE	GORY						
Landi	ng G	ear				General		_				-	-		
		Bending				Bend		Grain	,			Ovalized]		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		_	Over/Under	tolerance	$ _ $	Temperature/Cure
[Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorred	ct [Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
					Contamination		Maintenance				Part Moved	_			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	TH701
Description: Back Panel	Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1

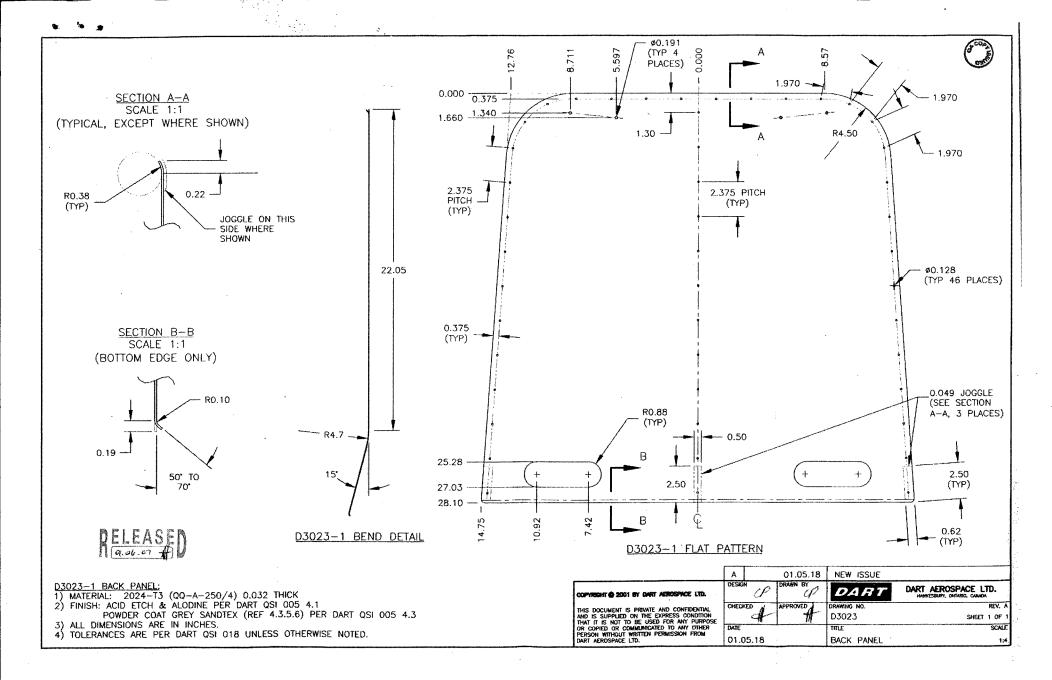
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Ø0.128	+0.005/-0.001			Inspection	
		,130	_	V	JKm-01
Ø0.191	+0.005/-0.001	192	_	V	
1.660	+/-0.010	1.660	_	V	
0.375	+/-0.010	1375	-	.,	
1.340	+/-0.010	1.340	_	J	
2.375	+/-0.010	2.375		 V	
0.375	+/-0.010	,375	-	V	
25.28	+/-0.030	25,28	_	T	JKM-06
27.03	+/-0.030	27.03	_	T	
28.10	+/-0.030	28.10	_	Т	
1.30	+/-0.030	1.30	og-	V	
2.375	+/-0.010	2.375	~	V	
8.711	+/-0.010	8.711	-	1	
5.597	+/-0.010	5.597	-	·V	
8.57	+/-0.030	8.57	-	Τ	
1.970	+/-0.010	1,970		 ·	
7.42	+/-0.030	7.42	_	T	
10.92	+/-0.030	10.92	-	Т	
14.75	+/-0.030	14.75	-	T	
 					

	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		
Measured by:	Audited by: 09	Prototype Approval:	N/A
Date: 13.10.01	Date: 13-10-01	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.11.27	New Issue	KJ/EC	X



13-09-24